

Work Order ID 149483

149483

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July 26, 2016 4:33:04 PM

Item ID: D206-642-311BL Repair Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube LH (ael Blue)

Start Date: 7/26/2016 Start Qty: 1.00 *1*

Required Date: 7/27/2016 Req'd Qty: 1.00 *1*

Reference: RMA RA112340

Cust Item ID:

Customer: CAEVA02

Approvals: Process Plan: SM Date: 7/26/16 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

105 0.00

105

QC

Quality Control

Memo

INSPECT D206-642-311BL REPAIR X 1 B114556 ON RA 112340 CHG007

① 16-07-27

DAS 9 9-63

106 0.00

106

Skidtubes

Skidtubes

Memo

TO PERFORM ITEMS 2-6 ON THE REPAIR SCHEME

① 16-7-27

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

① 16-07-27 PD

D206-642-312BL	CHG007
STC, RH	CH98-4
B114572	SAC
206L/L1/L3/L4/407	STC

B149483

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 149483

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Item ID: D206-642-311BL Repair Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube LH (ael Blue)
Start Date: 7/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/27/2016 Req'd Qty: 1.00 ***1*** Customer: CAEVA02
Reference: RMA RA112340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125									
Skidtubes	Memo	0.00							
Skidtubes	TO PERFORM ITEMS 8-10 ON THE REPAIR SCHEME								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
135	Identify as per dwg & Stock Location: _____	0.00							
135									
Packaging	Memo	0.00							
Packaging	ID AS REPAIR WITH NEW BATCH NUMBER AT CHANGE 007								
	RETURN TO CUSTOMER								

DAS
15
8-00

11 d 11 16/07/28

① 16-07-28 PD

SMB
16/7/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 149483

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Item ID: D206-642-311BL Repair Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH (ael Blue)
 Start Date: 7/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/27/2016 Req'd Qty: 1.00 ***1*** Customer: CAEVA02
 Reference: RMA RA112340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00				1	0	0	DAS 29 9-89
140									
QC	Memo								
Quality Control									

DOA TO 0.00 PROVIDE MAINTENANCE RELEASE- [Signature]

16/07/29

Sy 7/29/16

10/10/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Work Order ID: 149483

149483

Parent Item: D206-642-311BL Repair

D206-642-311BL Renair

Parent Item Name: Skidtube LH (ael Blue)

Start Date: 7/26/2016

Required Date: 7/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-311BL Repair		Manufactured	No				Each	0.0000		1			

D206-642-311BL Renair

Skidtube LH (ael Blue)

B114556

PD 16-07-29.

Repair scheme for D206-642

Skidtube Toe Ring Repair

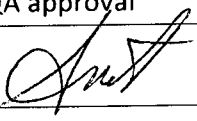
1. Remove Toe Ring and AN4 bolt from D2680-041 and end cap D2646
2. Clean D2680-041 to ensure a good bond when re-installed
3. Remove the remaining rivet by gripping the rivet tail with a small pair of bent needle nose pliers and prying gently while tapping with a small punch, while supporting the surface around the rivet
4. Countersink forward (2) holes to accommodate 1/8" rivets
5. Cleco D2680-041 onto Skidtube, if you find the surface to have uneven surface, gently tap the surface flat with the use of a bucking bar and hammer to flatten the surface, reinstall D2680-041 and open the 4 holes to #27 drill
6. Using a scotch brite pad in a Die Grinder, remove any corrosion and paint 1/8" around the perimeter of the D2680-041
7. Wipe clean, alodine and mask off prior to primer
8. Once the surface of the skidtube in the area of the repair is cured mix the CB200 adhesive and apply to the lower surface of the D2680-041, ensuring a nice equal layer of adhesive
9. Using 1/8" clecos position the D2680-041 into place and one by one install the CR3242-4-3
10. Let cure and install Toe Ring according to ICA-D206-642 Rev. 6 Chapter 32.6.3

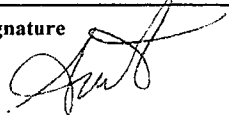
Material required (Consumable)

1. CR3242-4-3 Cherrymax Rivet
2. CB200 Adhesive
3. Primer
4. PRD 870, 1422 (as required)
5. Topcoat

Equipment Required

1. Hand Rivet Puller
2. Die Grinder with Roloc Mandrel
3. Scotchbrite pad, Medium Grit
4. Spatula
5. Hand Drill
6. 1/8" Clecos
7. Paint Sprayer, masking tape, paint brush

Perform by	QC approval	QA approval	DAS
	DAS		20
	9		8-89
	9-89		

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: SO127232	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice WPO-000020-16	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	Skidtube, LH	D206-642-311	1	B149483	Repaired	
12. Remarks: Skidtube P/N D206-642-341 repaired according to DART repair scheme on work order B149483. All additional customer supplied items were not inspected or repaired. To be evaluated by customer.						
13a. Certifies that the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.				14a. ☒ CAR 571.10 Maintenance Release ☐ Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .		
13b. Signature		13c. Approval Organization Number		14b. Signature		14c. Approved Organization Number
				 DAS 29 9-89		9-89
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name		14e. Date (dd/mm/yyyy):
				Patrick Smith		28/Jul/2016
30 Dec 2008(Previously form 24-0078)						
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified. Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						